

Date: Wednesday, 2/20/2008 4:23:25 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	EXTRUSION "I" BEAM TUBE 4"		
Job Number	37544			Part Number	D25001190		
Estimate Number	10154			Drawing Number	D2500 REV G		
P.O. Number				Project Number	N/A		
This Issue	2/20/2008	S.O. No.		Drawing Revision	G		
Prsh't Rev.	NC			Material			
First Issue	/ /	Type	PURCHASED PARTS	Due Date	3/17/2008	Qty:	80
Previous Run	34729			Um:	Each		
Written By	<u>10</u>						
Checked & Approved By	<u>2008 02 21</u>						
Comment	Est: G 02.09.05	Added DSK 066	KJ/RF	est	H 07.07.06	rev G dwg	EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING

Comment: PURCHASING

Issue P/O: 5770 C 2008/02/21
 a) Extrude as per Dwg D2500
 b) Material: 6061-T6 (QQ-A-200/8)
 c) Minimum yield tensile strength = 35 ksi
 d) Minimum ultimate tensile strength = 38 ksi
 e) Minimum elongation = 8%
 f) Order at 190" long
 g) Bon L Canada Inc. tool # 897105
 h) To be packed per DSK 066
 i) Pull test to ASTM standard B221 required.
 j) Material certification is required

80

2.0	D25001190P	Ext'n - 'I' Beam Tube 4"
		

Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 EXTRUSION "I" BEAM TUBE 4"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
		

Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

1/8/3/17 83

4.0	QC6	DIMENSIONAL CHECK
		

Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500
 Check Pull test per Dwg D2500 for compliance page attached.

1/8/3/20
37
46
23
83

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM TUBE 4"

Job Number: 37544

Part Number: D25001190

Job Number:



Seq. #: Machine Or Operation:

Description :

Check hardness with Webster tester

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Back Hse

BB 08/03/27 X83

6.0 QC21 FINAL INSPECTION/W/O RELEASE



83

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



MF

08-03-27

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PF</i>	APPROVED <i>PF</i>	DRAWING NO. D2500	REV. G	SHEET 1 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE	NTS
A	96.03.19	NEW ISSUE		
B	96.03.24	CHANGE INTERNAL WEB		
C	96.04.26	ADD D2500-3 WEB		
D	96.10.07	ADD MATERIAL PROPERTIES		
E	96.10.24	CHANGE MATERIAL TEMPER		
F	97.09.29	CHANGE MAT. TO 6061-T6		
G	07.04.17	ADD NOTES 3,5,6		

RELEASED
07.06.28-*PF*

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
 ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
 TO ENSURE THAT THE BATCH MEETS THE ABOVE
 MINIMUM MECHANICAL PROPERTIES

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. ALL DIMENSIONS ARE IN INCHES

4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.

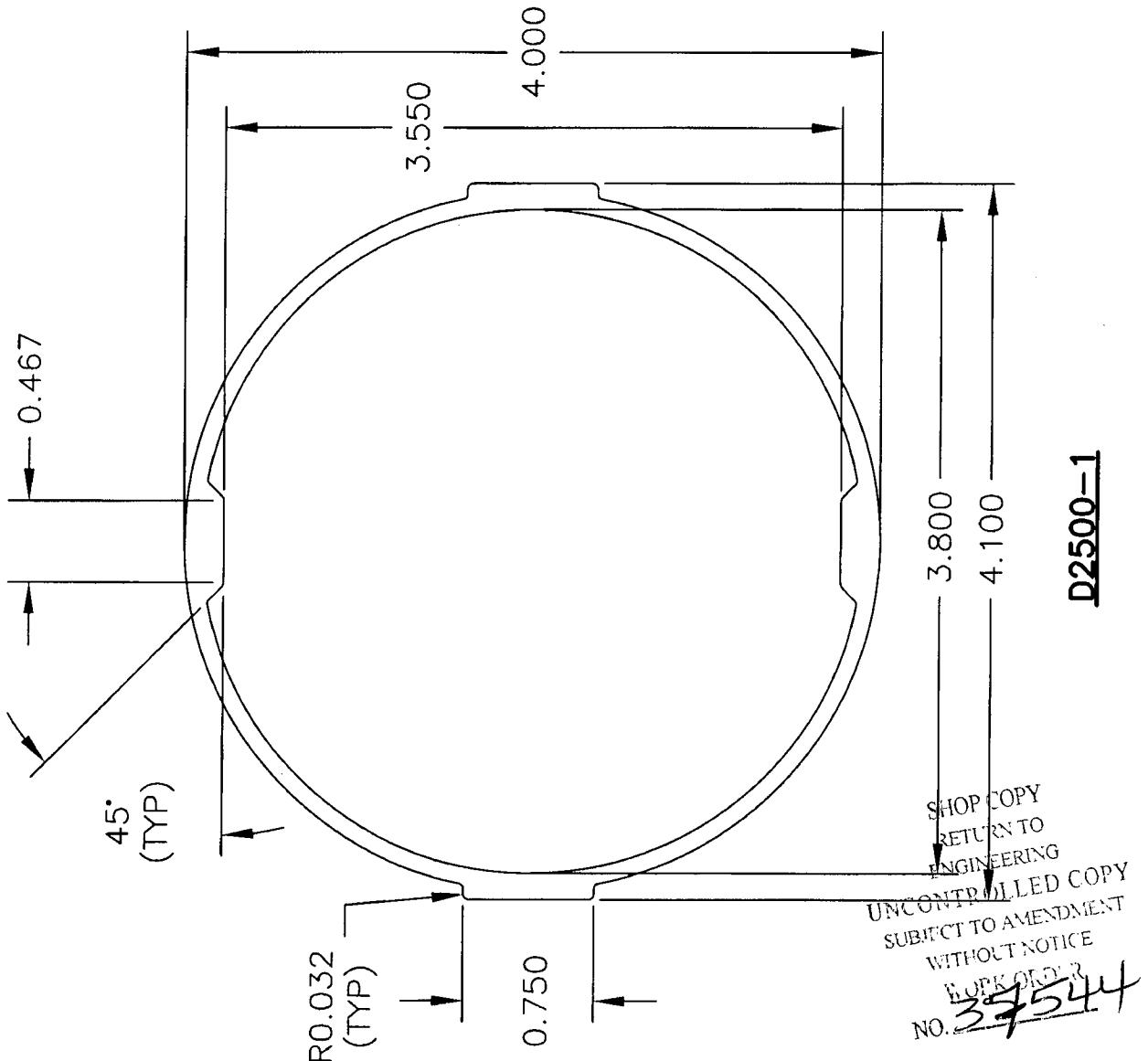
5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS
 CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
 D2500-1 EXTRUSION MANUFACTURED FROM:
 A) BON L DIE # 897015 -> PREFERRED
 B) CARADON MIDEAST DIE # PAH-28030
 C) CARADON MTL DIE # MH-18868

6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS
 CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
 D2500-3 EXTRUSION MANUFACTURED FROM:
 A) CARADON INDALEX DIE # MS-18867

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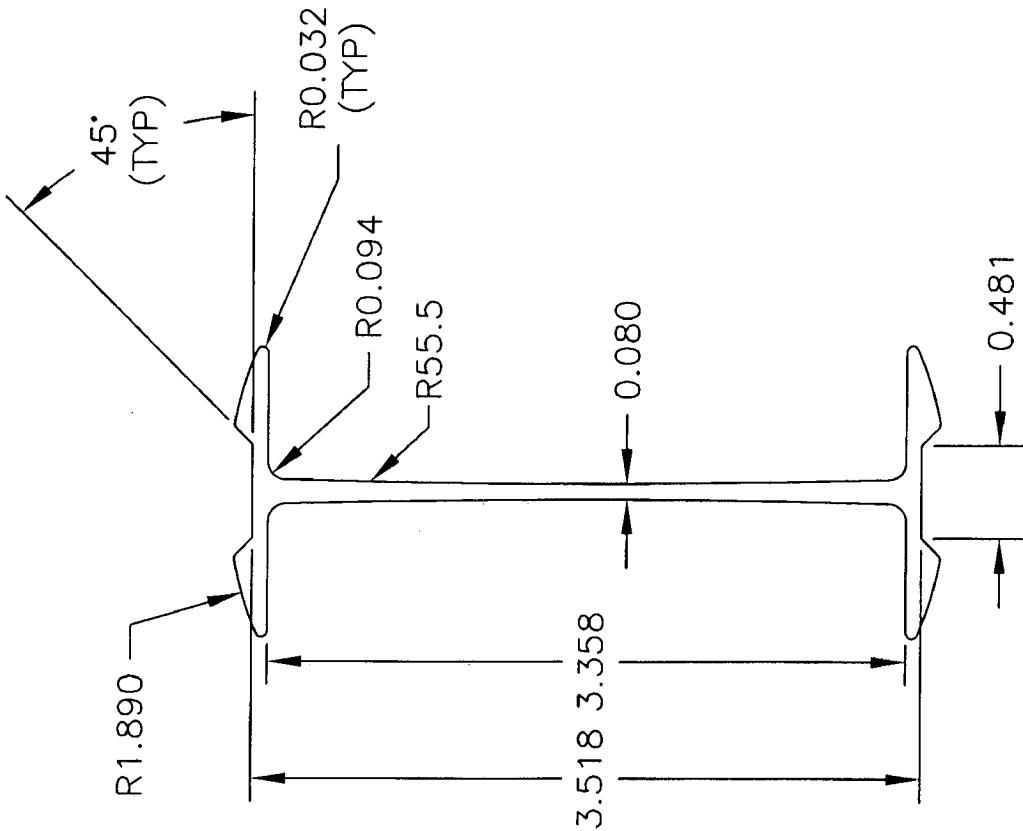
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2500 REV. G
DATE 07.04.17		SHEET 2 OF 3 TITLE EXTRUSION SCALE 1:1

RELEASED
07.06.28 ~~07.06.28~~



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2500 REV. G SHEET 3 OF 3
DATE 07.04.17		TITLE EXTRUSION SCALE 1:1

RELEASED
07.06.28

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ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

TERMS / FREIGHT
O / PREFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

SHIPPING MANIFEST
MANIFEST DATE
03-16-08
MANIFEST NUMBER
637736
SALES ORDER NUMBER
25906

CREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

FIELD SALES REP
Kutter A
450-435-6551CUST SERVICE REP
Burton D
905-427-2227

CUSTOMER ID
46024

ORDER DATE
02/25/08

CUSTOMER PO NUMBER
5770

LOCATION PIC	TRAILER NUMBER 57375	SALESMAN 59358	JOB	FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227
				BILL OF LADING NUMBER 08375540	

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER		FINISH DESCRIPTIONN FABRICATION DESCRIPTION		THIS SHIPMENT			UNIT	QUANTITY DUE		
					LENGTH		CUTTING TOLERANCE		NBR OF PKGS	GROSS POUNDS	NET QUANTITY				
					+5/16 "		-0 "								
01	80	KG M PC	0 0 0	DAA-897105-2 D2500-1-190	6061 /T6 190" +5/16 " -0 "			MILL CERTIFICATE OF COMP (+010-010,0088-0072)	4	1086	1054 400.56 83	KG M PC	0 0 0		
				LOT/TKT DETAIL: 0				25906010 / 264981 25906010 / 264982 25906010 / 264983 25906010 / 264984	1 1 1 1	301 301 301 183	293 293 293 175	PC PC PC PC	23 23 23 14		

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

4	1086	1054 400.56 83	KG M PC
TOTALS			

CERTIFICATE OF COMPLIANCE
SIGNATURE ALUMINUM CANADA

 1850 CLEMENTS ROAD
 PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
03/16/08	174785	25906	1
ConspO	B/L No.	Lot	Date
5770	08375540	25906010	3/16/08
Sold To	Ship To		
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-897105-2	190" Mill 6061 T6	D2500-1-190
Gross Weight	1086 KGS		
Net Wt.	1,054 KG	83 PC	401 M
Specification	AMS-QQ-A-200/8 & ASTM B221-06		

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	302.7 / 43.9	273.1 / 39.6	9.9	.0	92	
2	303.6 / 44.1	271.5 / 39.4	9.6	.0	92	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.66	.26	.25	.09	.84	.07	.05	.01
.61	.28	.25	.06	.89	.05	.05	.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

